

Date: Tuesday, 15/07/2008 4:19:58 PM
User: Julie Lecocq

split

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40532
Estimate Number : 12709
P.O. Number :
This Issue : 15/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : LARGE FAB ASSY
Previous Run : 39375

Written By :
Checked & Approved By : JHD DR.7.16
Comment : Est Rev:A New Issue 07-02-07 JLM
 est rev B revB dwg EC
 Est Rev:C Removed D3572-7 Cap 07-06-11
 Est Rev:D 08-05-27 Review process of Est.
 bv:EC

Drawing Name : GUIDE ASSEMBLY
Part Number : D3572041
Drawing Number : D3572 REV.C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 05/08/2008 Qty: 10 Um: Each

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
		
	Comment: PACKAGING RESOURCE #1	
	Pick Packing Kit	
2.0	D35723	Guide
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)	
	GUIDE	
	Batch: <u>B40562</u>	<u>EL 8-10-27 2020 X 17</u>
3.0	D35725	Bracket
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	BRACKET	
	Batch: <u>B32415</u>	<u>EL 8-10-27 2020 X 6</u>
4.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W
		
	Comment: Qty.: 2.3405 f(s)/Unit Total : 23.4045 f(s)	
	6061-T6 Round Tube 1.00" x 0.188 wall	<u>X5</u>
	Batch: <u>B704480</u>	<u>EL 8-10-27</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 40532

Part Number: D3572041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut Tube D3572-1 as per Dwg D3572

2-deburr both ends

ER 8-10-23

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572

A/R AL ROD Batch: M104855

ER 8-10-23 (X5)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 QC9 VISUAL WELDING INSPECTION



ER 08-10-27 (X5)

(X5)

Comment: VISUAL WELDING INSPECTION

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush at the end of tube only

ER 8-10-27 (X5)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-F 08/10/27 (X5)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:19:58 PM
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Drawing Name: GUIDE ASSEMBLY

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 POWDER COATING

POWDER COATING



M 106 442



(5X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:20

OVEN TEMPERATURE: 323°

FINISH TIME: 10:50

M-F 08/10/31

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ed



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-31 (5X)

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 247

88 08/11/03
08/11/03 (X5)

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/03 (X5)

Job Completion



U 08.11.03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

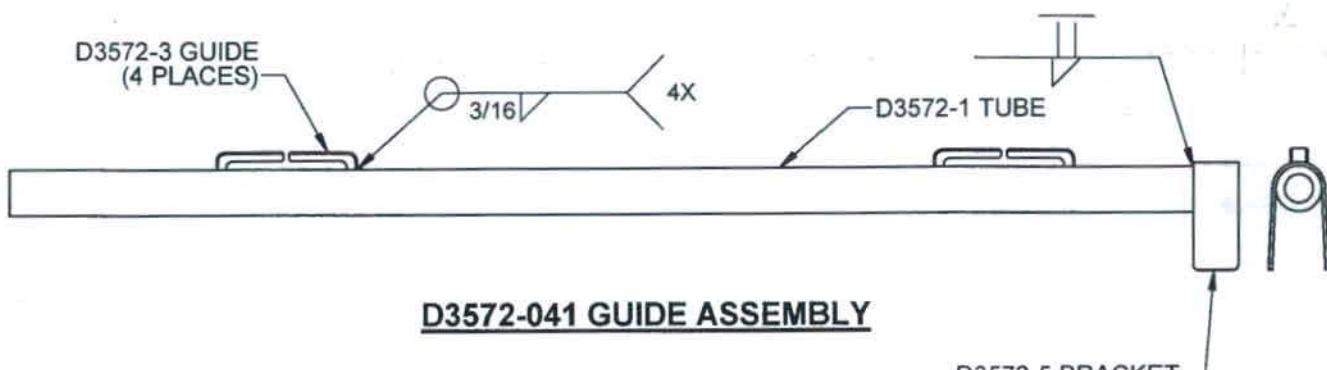
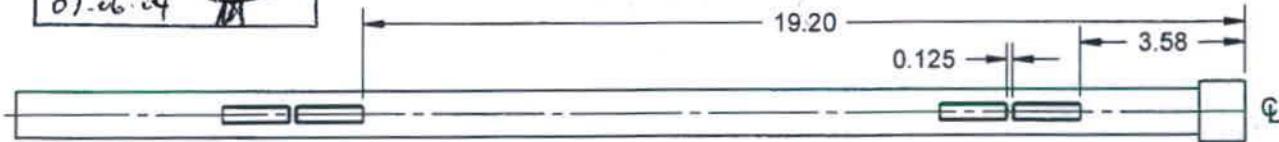
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

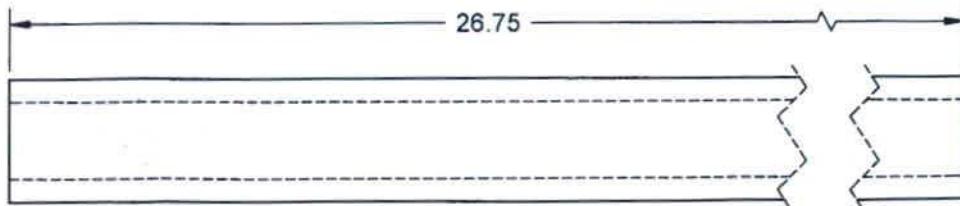
DESIGN <i>LG</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C	SHEET 1 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 1:4	
REV A	DATE 07.03.29	DESCRIPTION NEW ISSUE		
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET		
C	07.06.01	REMOVE D3572-7		

RELEASED07.06.01 *H***D3572-041 GUIDE ASSEMBLY**

D3572-5 BRACKET

D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE**0.188 (REF) *SH100 COPY**RETURN TO**ENGINEERING***UNCONTROLLED COPY****SUBJECT TO AMENDMENT****WITHOUT NOTICE****WORK ORDER****NO. 140532****D3572-1 NOTES:**

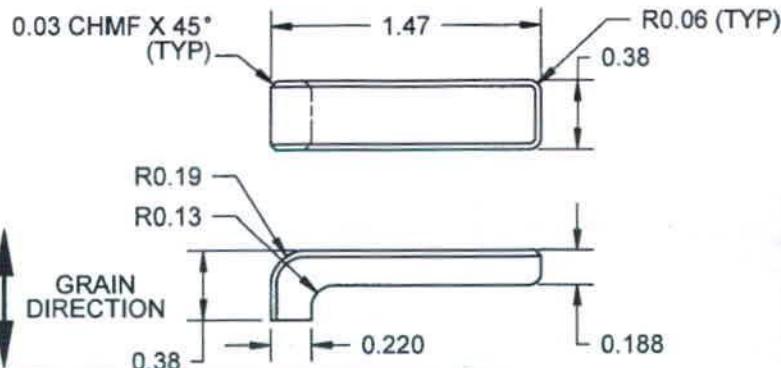
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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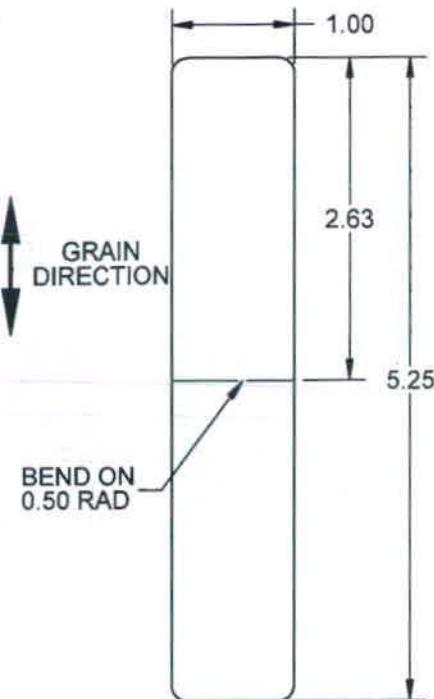
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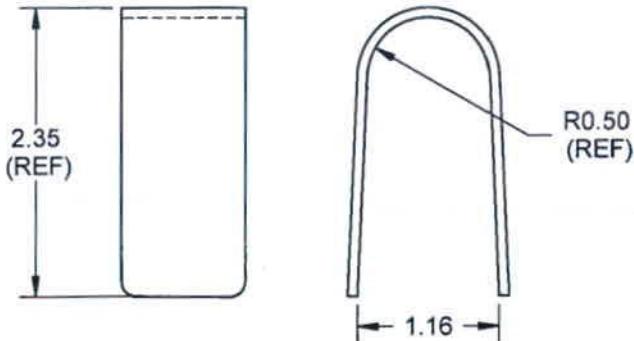
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 2:3



1 **D3572-3 GUIDE**



2 **D3572-5 FLAT PATTERN**



D3572-5 BRACKET
(MAKE FROM D3572-5F)

RELEASED

07.06.04 *H*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *40530*

D3572-3/5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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